



A standard linear barcode consisting of vertical black bars of varying widths on a white background.

Ship Via:

Instructions: FAA STC SA00475SE 18/06/17, 18/06/19 STC SH98-

DAS
24
3-88

JUN 07 2015

DAS
24
8-89

JUN 07 20

Plex 5/30/19 9:03 AM Dart:Guerin, Kimberley

		QC 9 - 9	
140 Handfinish - 1-1 Chemical- B4B	1 pcs	7/5/19	0.00 0.33
			Handfinish - 1 - 1 - B4B
			Handfinish - 1 - 2 - B4B
			Handfinish - 1 - 3 - B4B
			Handfinish - 1 - 4 - B4B
			Handfinish - 1 - 5 - B4B
			Handfinish - 1 - 6 - B4B
			Handfinish - 1 - 7 - B4B
			Handfinish - 1 - 8 - B4B
			Handfinish - 1 - 9 - B4B
			Handfinish - 1 - 10 - B4B
			Handfinish - 1 - 11 - B4B
			Handfinish - 1 - 12 - B4B
			Handfinish - 1 - 13 - B4B
			Handfinish - 1 - 14 - B4B
			Handfinish - 1 - 15 - B4B
			Handfinish - 1 - 16 - B4B
			Handfinish - 1 - 17 - B4B
			Handfinish - 1 - 18 - B4B
			Handfinish - 1 - 19 - B4B
			Handfinish - 1 - 20 - B4B
			Handfinish - 1 - 21 - B4B
			Handfinish - 1 - 22 - B4B
150 QC 7	1 pcs	7/5/19	0.00 0.00
			QC 7 - 10
			QC 7 - 13
			QC 7 - 14
			QC 7 - 15
			QC 7 - 17
			QC 7 - 18
			QC 7 - 19
			QC 7 - 2
			QC 7 - 28
			QC 7 - 3
			QC 7 - 30
			QC 7 - 34
			QC 7 - 36
			QC 7 - 37
			QC 7 - 41
			QC 7 - 47
			QC 7 - 48
			QC 7 - 51
			QC 7 - 58
			QC 7 - 59
			QC 7 - 60
			QC 7 - 9
			QC 7 - 68
			QC 7 - 50
			QC 7 - 67

 JUN 10 2019



					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
160 Skidtubes - 2 - B4B	1 pcs	7/5/19	0.00 2.00		Skidtubes - 1 - B4B	DD
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
180 Skidtubes - 3 - B4B	1 pcs	7/5/19	0.00 1.82		Skidtubes - 1 - B4B	DD
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
190 QC 5	1 pcs	7/5/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	BE
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
200 Skidtubes - 4 - B4B	1 pcs	7/5/19	0.00 2.84		Skidtubes - 1 - B4B	DD
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	BE
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
215 QC 9	1 pcs	7/5/19	0.00 0.00		QC 9 - 10	
					QC 9 - 18	DAS
					QC 9 - 24	24 JUN 20 2019
					QC 9 - 43	9-89
					QC 9 - 50	
					QC 9 - 9	
230 QC 5	1 pcs	7/5/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	DAS
					QC 5 - 24	24 JUN 20 2019
					QC 5 - 3	9-89
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 68	

240 Handfinish - 4-1-Assembly-B4B	1 pcs	7/5/19	0.00 0.78	QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	2-2 JUN 25 2019
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
250 Powdercoat - 1 White GI(A)-B4B	1 pcs	7/5/19	0.00 0.25	Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
260 QC 3	1 pcs	7/5/19	0.00 0.00	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
270 Handfinish - 4-2-Assembly-B4B	1 pcs	7/5/19	0.00 1.00	QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 -	

Hand 2

250 Powdercoat - 1 White GI(A)-B4B
M135489
START: 8:25 O.I.T. 300° FINISH: 8:55

BL 19-7-3

BEB 19-08-03

BEB 19-08-03

				B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
280 Handfinish - 3-1- WingWalk-B4B	1	7/5/19	0.00 0.60	Handfinish - 3 - 1 - B4B	
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
290 QC		7/5/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
300 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
310 Packaging 3-1 - Stock - B4B	1 pcs	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	

Need sign off
→

JUL 26 2019 40
9-89

JUL 26 2019 40
9-89

				Packaging 3 - 6 - B4B		DAS
				Packaging 3 - 7 - B4B		28
				Packaging 3 - 8 - B4B		9-89
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		AUG 02 2019
				Packaging 3 - 36 - B4B		
315 DC - 1 - B4B	1 pcs	7/5/19	0.00 0.00	DC - 1 - B4B		
				DC - 2 - B4B		
320 QC 21 - FG	1 pcs	7/5/19	0.00 0.00	QC 21 - FG - 21		AUG 02 2019
				QC 21 - FG - 70		

Part Op 110 - Skidtubes - 1-Deburr Fwd edge of tube 2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804 3-Weld
 Descriptions: Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required. *AK 139011/138789*

120 - QC5- Inspect part completeness to step on W/O

130 - QC9- Inspect visual per QSI004- Fusion Welds

140 - Chemical Conversion Coat per QSI005 4.1

150 - QC7-Inspect Chemical Conversion Coat

160 - Skidtubes -1-Open holes of detail B to finished size as per Dwg DEO D3804, (without cutting fluid) 2-C'sink one crossbolt spacer hole as per Dwg D3804 DEO Detail B(without cutting fluid) 3-Deburr and blow out all chips from inside the tube

180 - Skidtubes - 1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required 2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up.Allow 12 Hrs. cure time before cutting

190 - QC5- Inspect part completeness to step on W/O

200 - 1-Remove alodine in one area see DEO Detail B from around hole and prepare for welding 2-Prep per QSI 005 and Insert one D2649 crossbolt spacer. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

215 - QC9- Inspect visual per QSI004- Fusion Welds

230 - QC5- Inspect part completeness to step on W/O

240 - Pressure Wash per QSI005 4.3/ Clean and remove all markings) HandFinish4 Assemble as per dwg

250 - White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. START TIME: _____

260 - QC3- Inspect Part Finish

270 - HandFinish4 (Assemble as per dwg -- 1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive. 2- Install D2680-041 Nut Plate as per Dwg D2650

280 - Wing Walk as per dwg QSI005 4.4 Batch *SIF514* 1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

290 - QC3- Inspect Part Finish

300 - QC5- Inspect part completeness to step on W/O

310 - Identify and pack for shipping as per PPP D206-642-151 Location :FG107

Sika Flex. 5163437 EXD 12/09.

315 - Document Control - Photocopy bluefile & type labels per PPP D206-642-151 CHG004
 320 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2620	Skidtube, 206 Skidtube	1 pcs (1 ea)	110-Skidtubes - 1	5165744
D2647	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5166098
CR3212-4-04	Cherry Rivet	52 Ea (52 ea)	180-Skidtubes - 3 - B4B	517694
D2654-1	Web	1 pcs (1 ea)	180-Skidtubes - 3 - B4B	5059750
D3286-1	Doubler	2 pcs (2 ea)	180-Skidtubes - 3 - B4B	5166714
D2649	Cross Bolt Spacer	1 pcs (1 ea)	200-Skidtubes - 4 - B4B	5136881
D3286-3	Spacer	2 pcs (2 ea)	200-Skidtubes - 4 - B4B	5173052
D4720-1	Spacer	18 pcs (18 ea)	200-Skidtubes - 4 - B4B	5173039
D2651-1	Plug	6 pcs (6 ea)	270-Handfinish - 4-2-Assembly-B4B	5167951
D2651-3	O-Ring	6 pcs (6 ea)	270-Handfinish - 4-2-Assembly-B4B	5027453
D2680-041	Nut Plate	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	514543
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	270-Handfinish - 4-2-Assembly-B4B	51137622
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	270-Handfinish - 4-2-Assembly-B4B	51137886-0
AN3-37A	Bolt	7 Ea (7 ea)	280-Handfinish - 3-1- WingWalk-B4B	5194363
D2646	Aft Cap	1 pcs (1 ea)	280-Handfinish - 3-1- WingWalk-B4B	5160607
D3805-041	Run-on Landing Wearplate Fwd	1 pcs (1 ea)	280-Handfinish - 3-1- WingWalk-B4B	5145465
D3805-045	Run-on Landing Wearplate Aft	1 pcs (1 ea)	280-Handfinish - 3-1- WingWalk-B4B	5187203
D3873-1	Bushing	14 pcs (14 ea)	280-Handfinish - 3-1- WingWalk-B4B	8x515778/519346 2x6
MS21042L3	Nut	7 Ea (7 ea)	280-Handfinish - 3-1- WingWalk-B4B	5157462-1
MS27039-1-08	Screw	2 Ea (2 ea)	280-Handfinish - 3-1- WingWalk-B4B	5180295
MS27039-4-06	Screw	1 Ea (1 ea)	280-Handfinish - 3-1- WingWalk-B4B	5166974-1
NAS1149D0332J	Washer	2 Ea (2 ea)	280-Handfinish - 3-1- WingWalk-B4B	5128378
NAS1149D0363J	Washer	7 Ea (7 ea)	280-Handfinish - 3-1- WingWalk-B4B	5176545
NAS1149D0463J	Washer	1 Ea (1 ea)	280-Handfinish - 3-1- WingWalk-B4B	5055952

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2620	1	4	0
	D2647	1	43	0
180-Skidtubes - 3 - B4B	CR3212-4-04	52	631	0
	D2654-1	1	3	0
	D3286-1	2	36	0
200-Skidtubes - 4 - B4B	D2649	1	70	0
	D3286-3	2	24	0
	D4720-1	18	222	0
270-Handfinish - 4-2-Assembly-B4B	CCR264SS3-3	2	159	0
	CR3212-4-03	2	84	0
	D2651-1	6	95	0
	D2651-3	6	304	0
	D2680-041	1	11	0
280-Handfinish - 3-1- WingWalk-B4B	AN3-37A	7	71	0
	D2646	1	33	0
	D3805-041	1	15	0
	D3805-045	1	4	0
	D3873-1	14	85	0
	MS21042L3	7	2,144	0
	MS27039-1-08	2	467	0
	MS27039-4-06	1	95	0
	NAS1149D0332J	2	3,596	0
	NAS1149D0363J	7	1,446	0
	NAS1149D0463J	1	3,447	0

Part Specifications

Specifications could not be found.

Plex 5/30/19 9:03 AM Dart.Guerin.Kimberley

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2650-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11	1	1	D2654-3	WEB
12	1	1	D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN980JD10L	WASHER
22	1	1	AN980JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27038-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 LB
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/281 ADHESIVE PER DART QSI 015
12) INSERT D2651-1 PLUG CW D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

DEO ATTACHED

RELEASED
R 07 09 03 03
per E2-N 07-576

REV.	NEW ISSUE	DESCRIPTION	MB	BY	DATE
DESIGN					
DRAWN					
CHECKED					
MFG. APPR.					
APPROVED					
DATE	08.07.07				

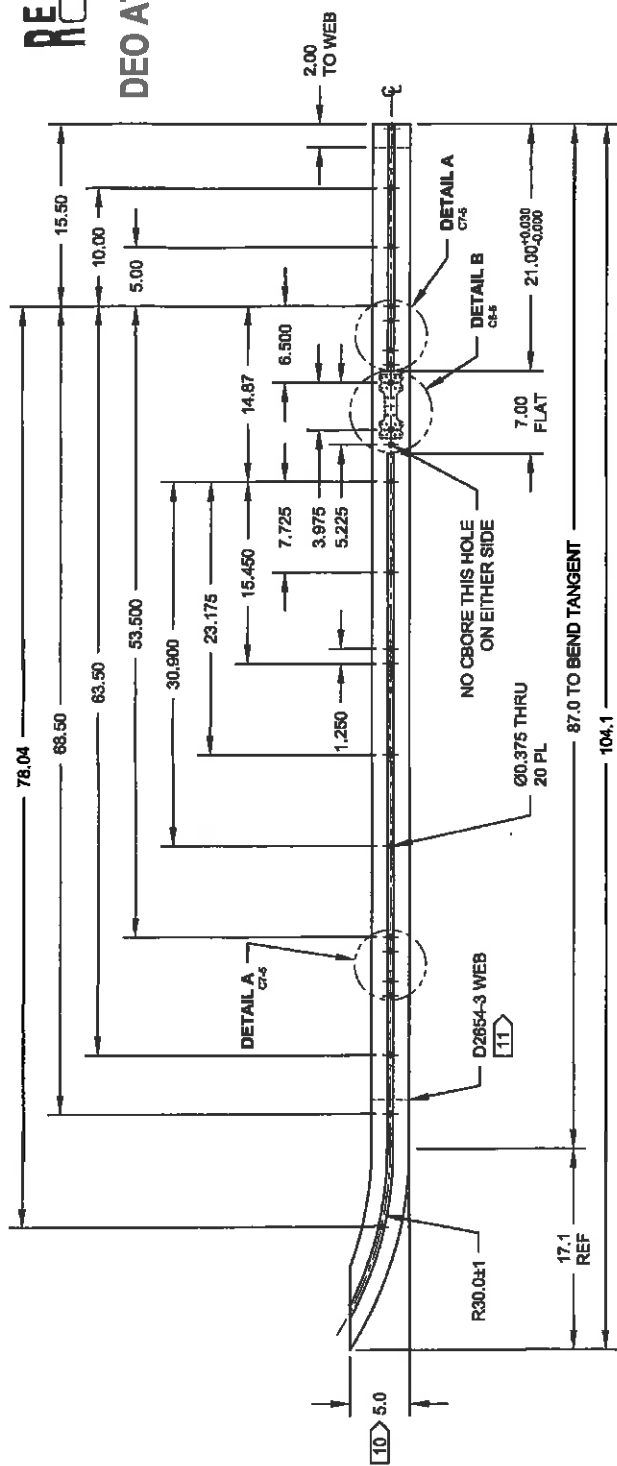
DART AEROSPACE USA, INC	
PORT HADLOCK, WA	
DRAWING NO.	REV. A
D3804	SHEET 1 OF 5
TITLE	SCALE
SKIDTUBE ASSEMBLY, 206A/B	NTS
COPYRIGHT © 2008 BY DART AEROSPACE USA, INC	
ALL RIGHTS RESERVED. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.	

DEO ATTACHED

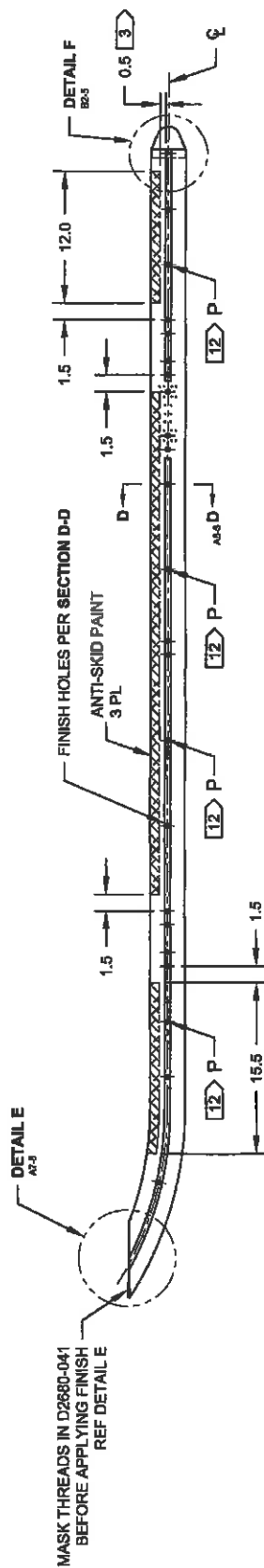


DESIGN DRAWN	09	DART AEROSPACE USA, INC PORT HADLOCK, WA			
CHECKED	01	DRAWING NO.	D3804	REV. A	SHEET 2 OF 5
MFG. APRR.	02	TITLE	SCALE		
APPROVED	03	SKIDTUBE ASSEMBLY, 206A/B		NTS	
DE APRR.	04	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC			
DATE	08.07.07	This drawing is the property of DART AEROSPACE USA, INC. It is to be used for the purpose intended and is not to be reproduced, stored in a retrieval system, or transmitted, in any form or by any means, electronic, mechanical, photocopying, recording, or by any information storage and retrieval system, without the prior written permission of DART AEROSPACE USA, INC.			

DEO ATTACHED



D3804-043 BENDING/DRILLING DETAIL

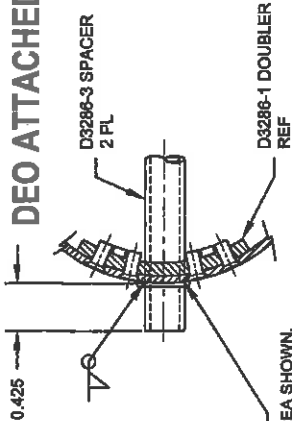


D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN	DART AEROSPACE USA, INC			
DRAWN	PORT HADLOCK, WA			
CHECKED	DRAWING NO.	REV. A	SHEET 3 OF 9	
MFG. APPR.	D3804			
APPROVED	TITLE	SCALE		
DE APPR.	SKIDTUBE ASSEMBLY, 206A/B	NTS		
DATE	08.07.07			

RELEASED
R 09.05.03

DEO ATTACHED



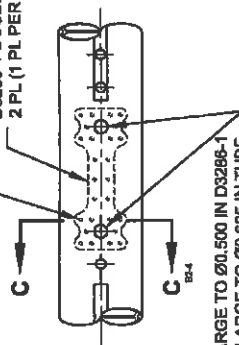
TO INSTALL D3286-1/3:

1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
3. ENLARGE HOLES IN D3286-1 TO $\varnothing 0.500$
4. ENLARGE HOLES IN TUBE TO $\varnothing 0.825$ AND CHAMFER HOLE $0.03 \times 45^\circ$
5. RIVET D3286-1 TO TUBE
6. INSERT D3286-3 SPACER
7. WELD IN PLACE AND GRIND FLUSH

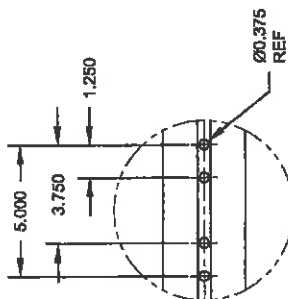
SECTION C-C C3-4
PARTIAL SECTION
SCALE NONE

$\varnothing 0.128$ THRU WALL
CSINK $\varnothing 0.228 \times 100^\circ$
INSTALL CR3212-4-04 RIVET
52 PL (26 PL PER DOUBLER)

D3286-1 DOUBLER
2 PL (1 PL PER SIDE)

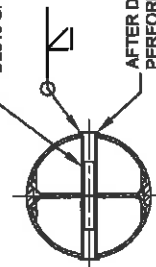


DETAIL B C3-2
C3-3
SCALE NONE



DETAIL A D3-2
C3-2
D3-3
C3-3
SCALE NONE

D2849 SPACER



AFTER DRILLING AND BENDING ASSEMBLY

PERFORM THE FOLLOWING FOR $\varnothing 0.375$ HOLES ONLY:

1. CHAMFER HOLE $0.03 \times 45^\circ$
2. INSERT D2849 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. BORE TO $\varnothing 0.313 \times 0.75$ DP (EXCEPT WHERE INDICATED)

SECTION D-D A4-2
A4-3
FOR $\varnothing 0.375$ HOLES ONLY
SCALE NONE

DESIGN	01	DART AEROSPACE USA, INC
DRAWN	1	PORT HADLOCK, WA
CHECKED	07	DRAWING NO.
MFG. APPR.	02	D3804
APPROVED	07	TITLE
DE APPR.	07	SKIDTUBE ASSEMBLY, 206AB
DATE	08.07.07	NTS
REV. A SHEET 4 OF 5		
COPYRIGHT © 2006 BY DART AEROSPACE USA, INC ALL RIGHTS RESERVED. NO PART OF THIS PUBLICATION MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.		

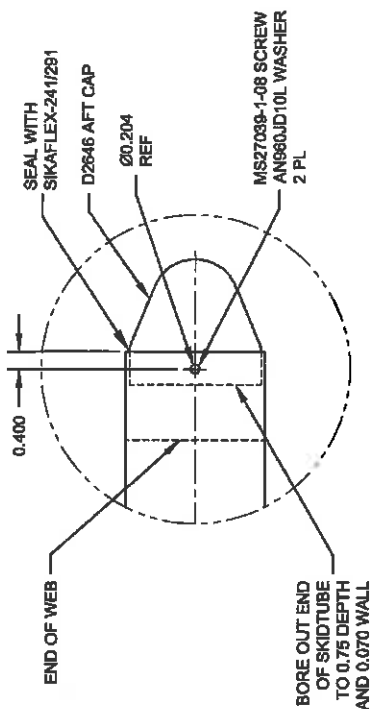
RELEASED
R 09.03.03

DEO ATTACHED

CR3212-4-03 RIVET
2 PL

CCR264SS3-3
RIVET
2 PL

VIEW G-G
SCALE NONE



DETAIL F
SCALE NONE

- D2647 CAP. TO INSTALL:
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS REQD)
 4. WELD D2647 IN PLACE
 5. GRIND FLUSH
 6. RIVET D2680-041 NUT PLATE IN PLACE

MS27039-4-06 SCREW
AN980JD416 WASHER
D2680-041
NUT PLATE

1.0 REMOVE RIDGE ON
INSIDE OF SKIDTUBE
LEAVE 0.070 MIN.

DETAIL E
SCALE NONE

DESIGN	41	DART AEROSPACE USA, INC
DRAWN	1	PORT HADLOCK, WA
CHECKED	2	DRAWING NO.
MFG. APPR.	3	D3804
APPROVED	4	REV. A
DE APPR.	5	SHEET 5 OF 5
DATE	08.07.07	TITLE
		SKIDTUBE ASSEMBLY, 208A/B
		SCALE
		NTS

Copyright © 2008 by DART Aerospace USA, Inc.
All rights reserved. No part of this publication may be reproduced, stored in a retrieval system, or transmitted, in any form or by any means, electronic, mechanical, photocopying, recording, or by any information storage and retrieval system, without permission in writing from DART Aerospace USA, Inc.

DRAWING NO. D3804	TITLE SKIDTUBE ASSEMBLIES, 206A/B	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3804-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN CP	CHECKED A.R.	DATE 12.10.22	MFG. APPR. [Signature]	APPROVED [Signature]	DATE 12-10-22	DE APPR. [Signature]	DATE 12-10-22

PURPOSE:
CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:
PARTS LIST IS AMENDED AS FOLLOWS:

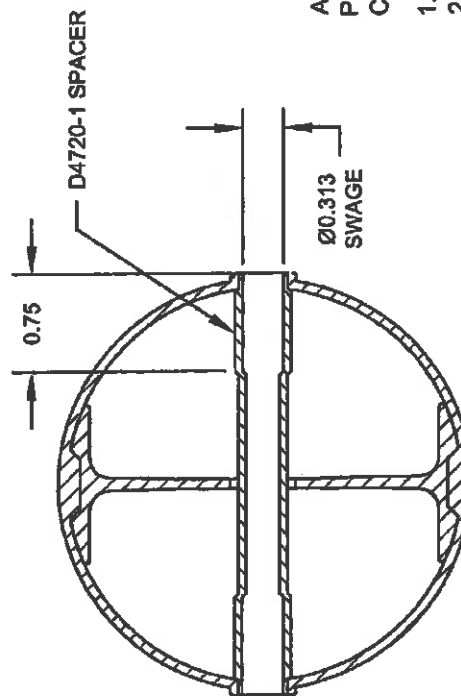
IS:

QTY	QTY	PART NUMBER	DESCRIPTION
-041	1	D2649	CROSS BOLT SPACER
18	19	D4720-1	SPACER

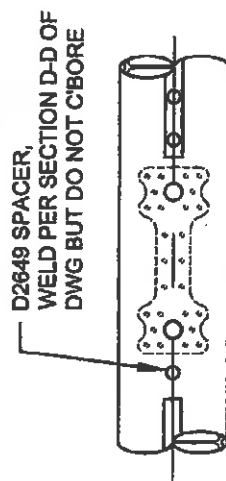
WAS:

19	20	D2649	CROSS BOLT SPACER
----	----	-------	-------------------

ADD SECTION H-H BELOW, WHICH IS THE SAME SECTION VIEW AS SECTION D-D OF DWG. C'BORED HOLES ARE NOW SWAGED PER SECTION H-H BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER SECTION D-D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



SECTION H-H
FOR Ø0.375 HOLES ONLY
FOR HOLES THAT ARE CURRENTLY C'BORED ONLY
NOT TO SCALE



DETAIL B
AMENDMENT TO DETAIL B
NOT TO SCALE

RELEASED
2012-11-16

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 18 PL (-041) OR 19 PL (-043)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002